

# Work Order ID 83045

April-12-12 1:02:09 PM

**\*83045\***

Page 1

Item ID: D3270-041  
Revision ID:  
Item Name: Fuel Scupper Assembly

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Start Date: 12/04/2012 Start Qty: 12.00  
Required Date: 26/04/2012 Req'd Qty: 12.00

**\*12\***  
**\*12\***

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/12 Tooling:  
QC: Date: SPC (Y/N):

Date:

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3270	Rev B								
100		0.00							
<b>*100*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Cut D3270-3 as per Dwg D3270								
110		0.00							
<b>*110*</b>	Weld per dwg A/R Aluminum rod Batch: <u>122358</u>	0.00							
Large Fab	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld D3270-3 to D3270-1 as per Dwg D3270 using welding Jig D3270-041T1 and QSI 004.								
120		0.00							
<b>*120*</b>	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

13 #1 12-10-18

12 1 12-10-18

12 12-10-19



Handwritten signature/initials.

W/O: 83045		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3270-041 PAR #: \_\_\_\_\_ Fault Category: large FAD. NCR: Yes No DQA: AK Date: 12/11/02  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 2/11/05

NCR: 12-2002		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/10/02	# 110	Qty 1 part scrap due to welding caused the tubing to be ragged. caused the hole in the tube to be smaller w/ch. with time for the tubing to pass through. RC improve welding process.	(DAS 16 2-03) ASZ 2012	Scrap + destroy 1 qty 1 part and replace D3270-1 B 72362 D3270-3 B M112638 x1	AK 12.10.22	(DAS 16 2-03) QSF 2012	(DAS 16 2-03) 12/10/22	
			12/10/22	A/E <del>122588</del> 122358	AK 12.10.22	(DAS 16 2-03) 12/10/22		

10.29  
10.29

NOTE: Date & initial all entries

# Work Order ID 83045

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Item ID: D3270-041  
Revision ID:  
Item Name: Fuel Scupper Assembly

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 12/04/2012 Start Qty: 12.00 **\*12\***  
Required Date: 26/04/2012 Req'd Qty: 12.00 **\*12\***

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

START Time:

OVEN TEMPERATURE:

FINISH TIME:

3-40  
3200 F

4-10

42

12 12-10-23

12x 12/10/24

m122878

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83045

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Item ID: D3270-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Fuel Scupper Assembly

Stop

**\*NS2\***

Start Date: 12/04/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/4/12 12/10/12

165

Identify as per dwg & Stock Location

0.00

**\*165\***

Packaging

Memo

0.00

Packaging

PPP 88247-8x  
PPP 88990 -2x  
PPP 86609 -2x

12/4/12 12/10/12

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/10/31

12/10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83045

\*83045\*

Parent Item: D3270-041

\*D3270-041\*

Parent Item Name: Fuel Scupper Assembly

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3270-1		Manufactured	No			100	Each	61.0000	1	12			
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\*D3270-1\*

Mounting Base

Location

Loc Qty

Loc Code

WA022

61

24076

43

72362

18

M6061T6T0.375W.035

Purchased

No

100

f

163.2082

0.6666

8.420211

\*M6061T6T0 375W 035\*

6061-T6 RD Tube .375 x.035W

Location

Loc Qty

Loc Code

MAT014

163.2082

112652

163.2082

\*\*

12.10.18

\*\*

12.10.18

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

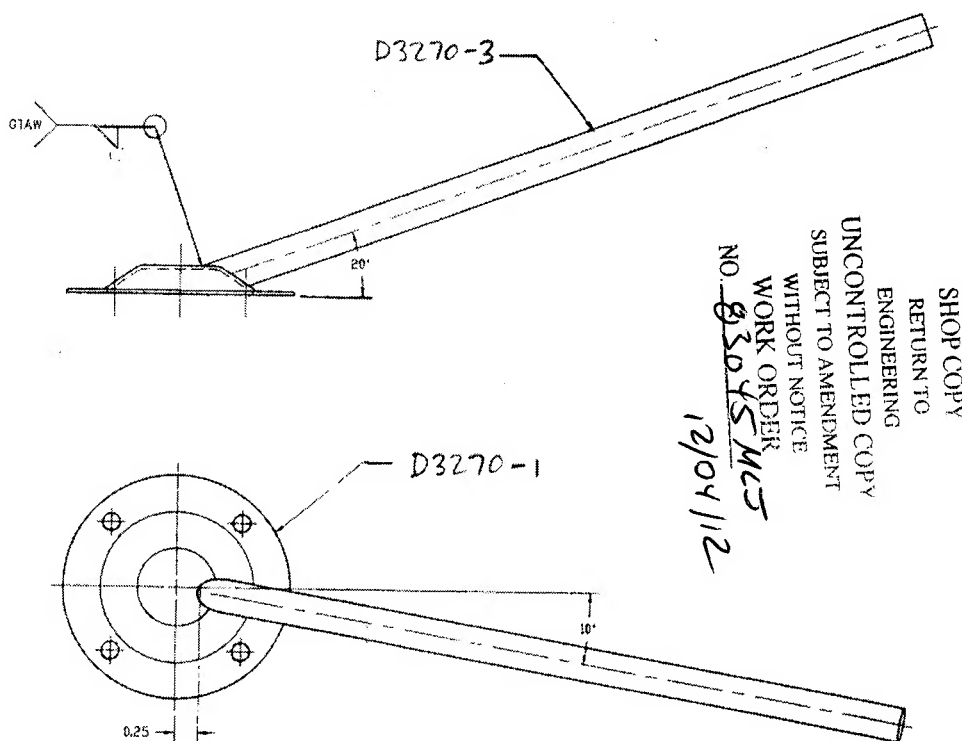
**NOTE:** Date & initial all entries





DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE 05.07.14		TITLE FUEL SCUPPER DRAIN ASSEMBLY	SCALE NTS
A	04.02.20	NEW ISSUE	
B	# 05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED  
04.02.20



D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
  - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

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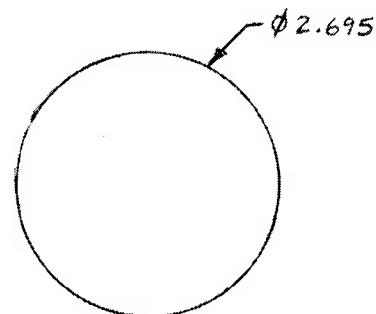
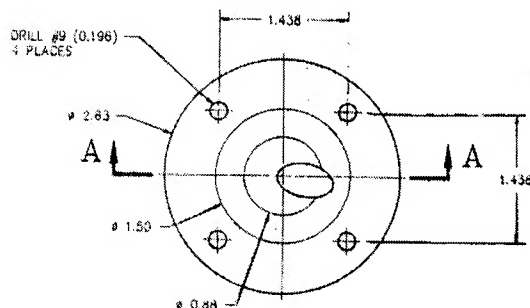


DESIGN	<i>HH</i>	DRAWN BY	<i>HH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CP</i>	APPROVED	<i>HH</i>	DRAWING NO. <i>D3270</i>
DATE	05.07.14	TITLE	FUEL SCUPPER ASSEMBLY	REV. B SHEET 2 OF 2 SCALE NTS
A	04.02.20	NEW ISSUE		
B	<del>HH</del> 05.07.14	ADD D3270-1 FLAT PATTERN		

RELEASED  
04.02.23 *CP*



SECTION A-A



D3270-1 FLAT PATTERN

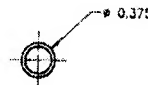


D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT  
D3270-1



D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)  
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8  
(M6061T6T0.375W.035)

03045

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